

Work Order ID 74149

Monday, September 26, 2011 9:49:17 AM



MAP

Page 1

Item ID: D4406-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Wearplate Assembly

Start Date: 9/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4406

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per dwg D4406

prog rev: A

dwg rev: A

2-Deburr if required

B11-9-27

4

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-9-27

10

10

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Page 2

Item ID: D4406-043

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Start Date: 9/26/2011 Start Qty: 4.00

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Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

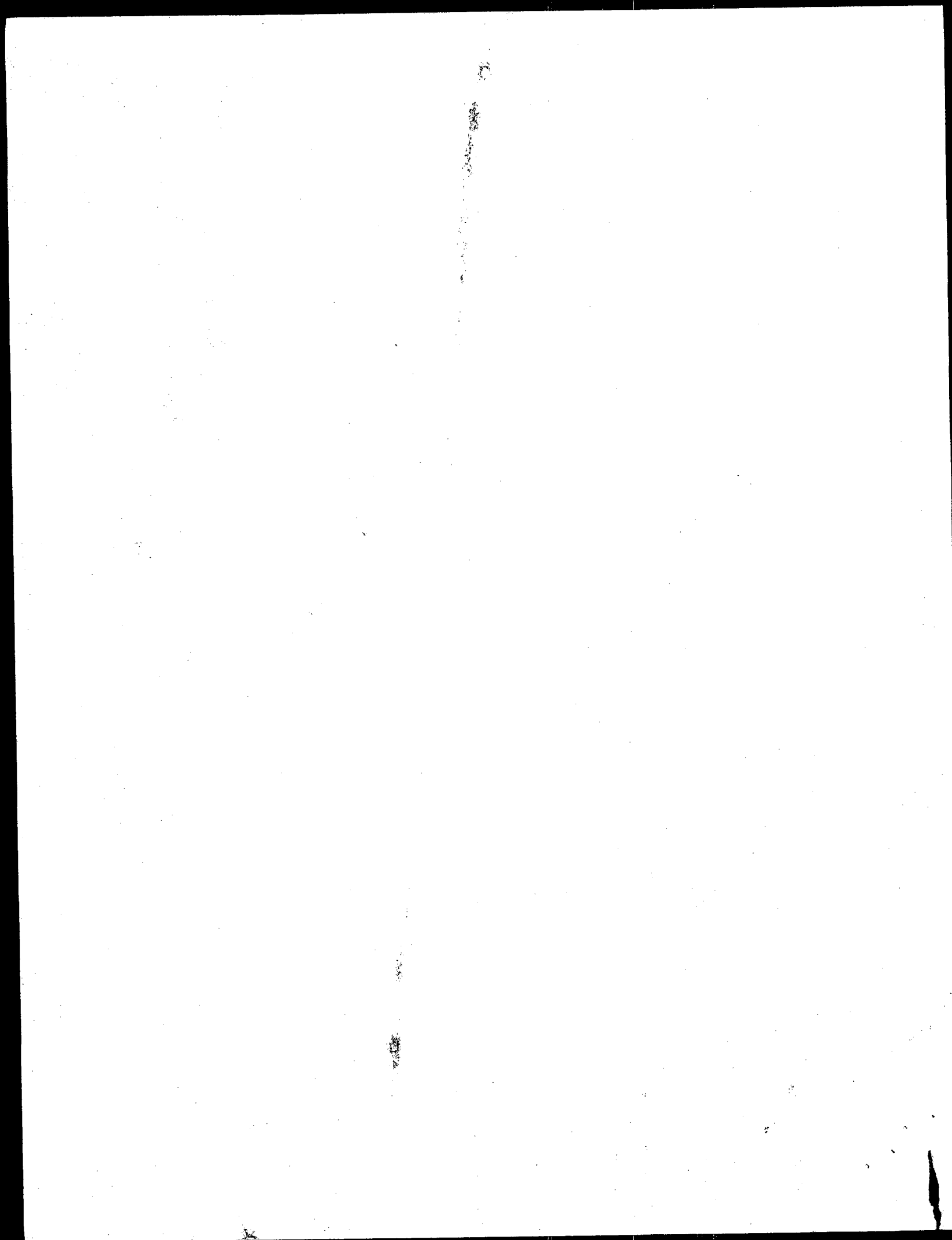
QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		SB 11/09/27		(74)			
130 Small Fab Small Fab	 Memo Form as per dwg D4406	0.00 0.00		SB 11/09/29		(4)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		SB 11/09/29		(74)			



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Required Date: 10/14/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00



Large Fab

Memo

weld wearplate as per dwg D4406

0.00

Large Fab

2059B - M119373

EZ

12-11-29

2059B - M119615

JBL

11-11-29

160

0.00



QC

Quality Control

Memo

0.00

Pl 11-11-30

4x



170

0.00



Small Fab

Memo

Apply coating as per dwg D4406

0.00

ET 11-11-30



Work Order ID 74149

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Page 4

Item ID: D4406-043

Accept



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Start Date: 9/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11/12/01 ①

190

Identify as per dwg & Stock Location: FP-2

0.00



Packaging

Memo

0.00

Packaging

4x 11/12/01
COUNTED & MEASURED

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/12/11

11-12-1

Picklist Print

Monday, September 26, 2011 9:49:15 AM

Page 1

Work Order ID: 74149

Parent Item: D4406-043

Parent Item Name: Aft Wearplate Assembly





Start Date: 9/26/2011

Required Date: 10/14/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev A 11.06.06new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4407-3 		Manufactured	No			150	Each	0.0000	1	4			
Bar M304S18GA 		Purchased	No			100	sf	55.5550	3.21	13.51579			
304/316 .050 Sheet													

Location

Loc Qty

Loc Code

MAT020

55.555

113062

0.155

116979

55.4

119032

119032

4

74152 x 4

EL 11-11-28

1311-9-27

DART AEROSPACE LTD		Work Order: 74149
Description: ACT WEAR PLATE ASSEMBLY		Part Number: D4406-03
Inspection Dwg: D4406-3, Rev: A		Page 1 of 1

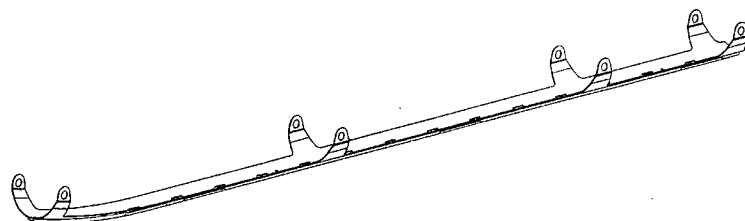
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

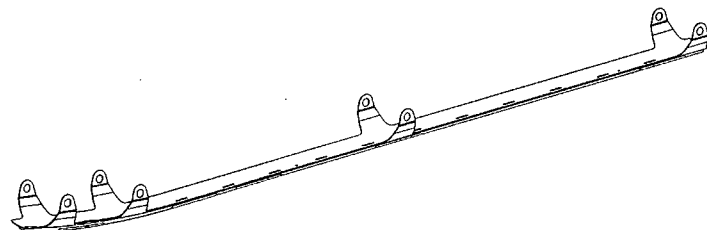
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.561	$\pm .010$.562	X		V HB2	
.130	$\pm .030$.282	2		V	
.88	$\pm .030$.88	2		V	
.13	$\pm .030$.125	2		V	
.31	$\pm .030$.313	2		V	
1.76	$\pm .030$	1.758	2		V	
24.945	$\pm .010$	24.995	2		T B01	
47.833	$\pm .010$	47.833	P		T	
54.053	$\pm .010$	54.053	X		T	
2.43	$\pm .030$	2.434	2		V	
7.567	$\pm .010$	7.561	1		V	
8.17	$\pm .030$	8.165	2		V	
7.78	$\pm .030$	7.775	2		V	
7.133	$\pm .010$	7.135	2		V	
7.77	$\pm .030$	7.773	2		V	
7.203	$\pm .010$	7.200	3		V	
3.63	$\pm .030$	3.628	2		V	
7.00	$\pm .030$	7.003	2		V	
4.00	$\pm .030$	3.997	1		V	
.050	$\pm .010$.048	2		V	

Measured by: JB	Audited by: S	Prototype Approval:
Date: 11-9-21	Date: 11/9/21	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4406-041 FWD WEARPLATE ASSY



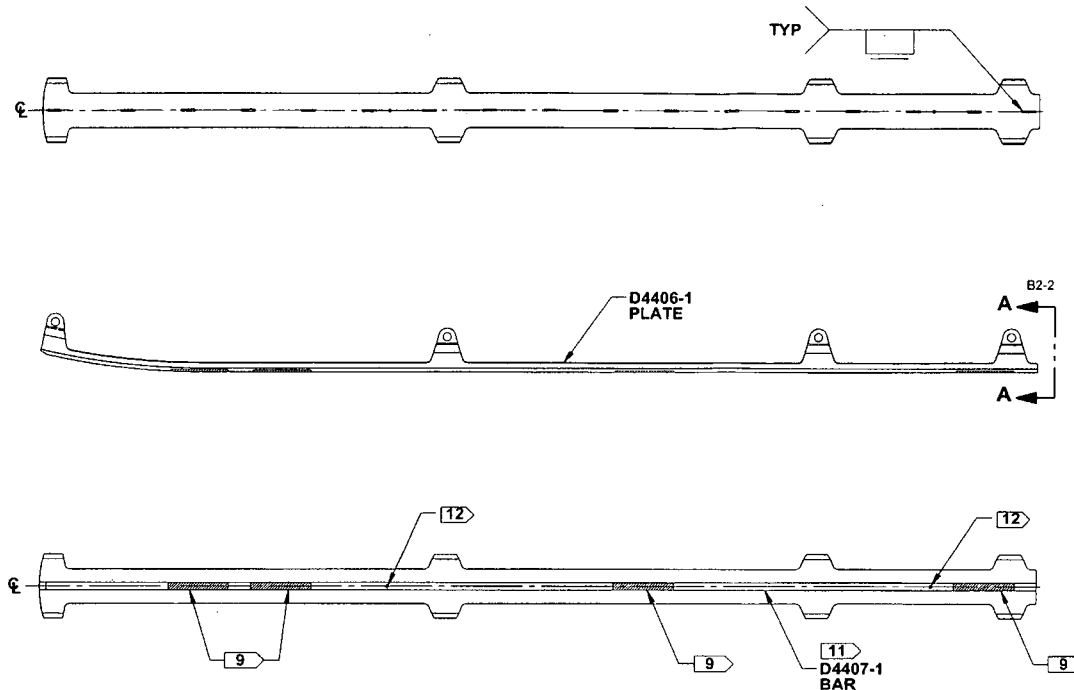
D4406-043 AFT WEARPLATE ASSY

also 74149

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D4406-041	FWD WEARPLATE ASSY
2		X	D4406-043	AFT WEARPLATE ASSY
3	1		D4406-1	PLATE
4		1	D4406-3	PLATE
5	1		D4407-1	BAR
6		1	D4407-3	BAR
7	A/R	A/R	2059B	HARDCOAT
8	A/R	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2 & 3)

RELEASED
2011-08-29

A NEW ISSUE		RF	11.08.15
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4406	SHEET 1 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
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D4406-041 FWD WEARPLATE ASSY

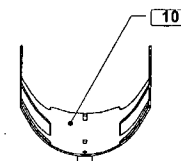
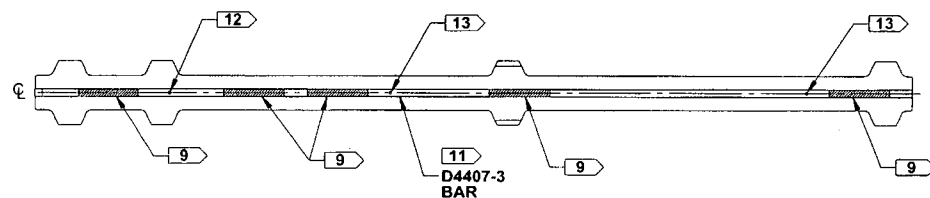
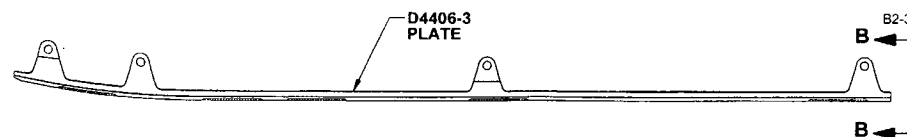
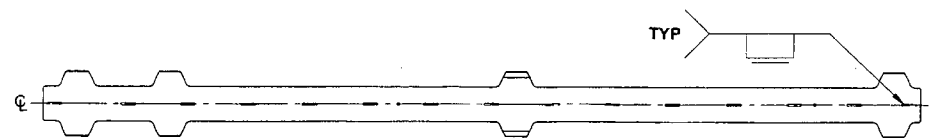
C3-2 **SECTION A-A**
SCALE 2X

RELEASED
2011-08-29
JW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 5.12 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D4407-1 BAR ON ALL 3 SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING
- 12) TRANSFER Ø0.188 HOLES FROM D4406-1 TO D4407-1

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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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
D4406-043 AFT WEARPLATE ASSY

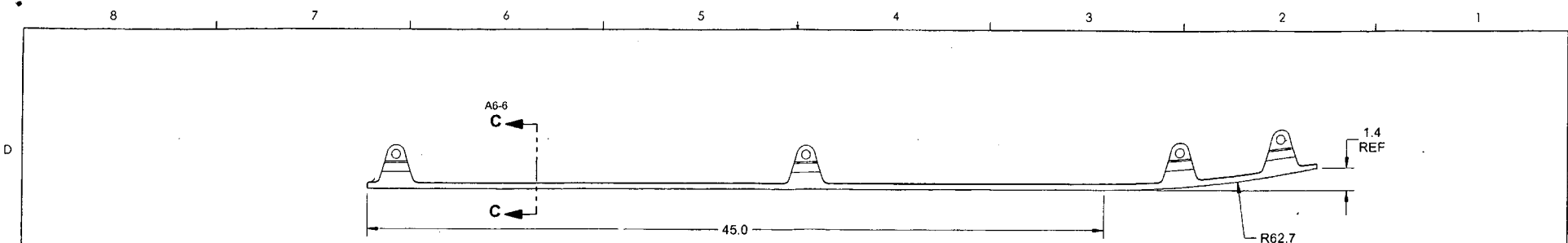
C3-3 **SECTION B-B**
SCALE 2X

NOTES:

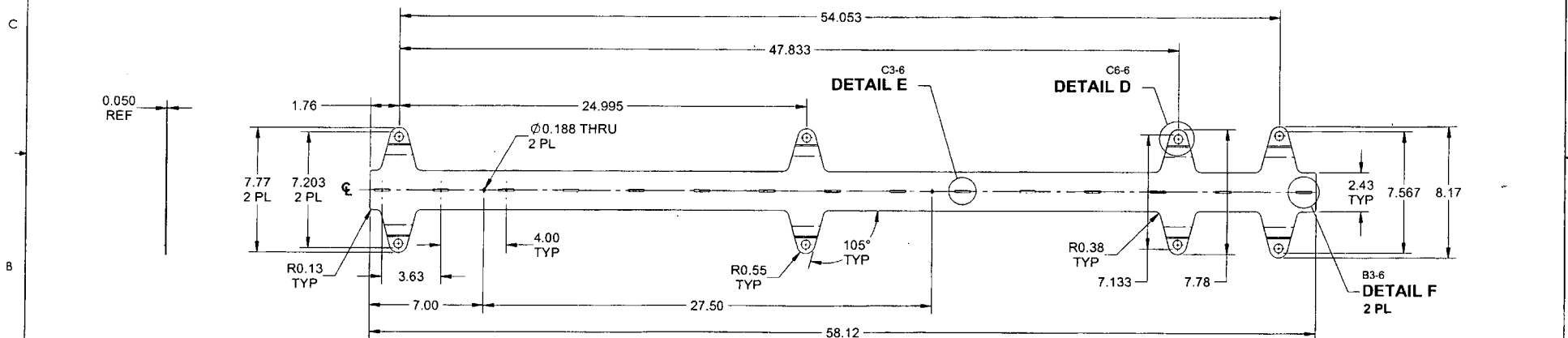
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 4.57 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D4407-3 BAR ON ALL 3 SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING
- 12) FILL TOOLING HOLE WITH WELD ONE PLACE ONLY
- 13) TRANSFER $\varnothing 0.188$ HOLES FROM D4406-3 TO D4407-3

RELEASE
2011-08-29

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MFG. APPR.		D4406	SHEET 3 OF 6
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D4406-3 PLATE
(MAKE FROM D4406-3F)



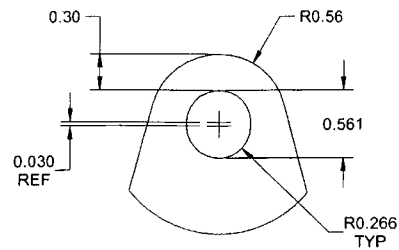
D4406-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.33 lbs

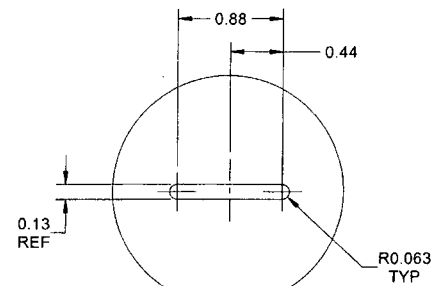
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MFG. APPR.	<i>DS</i>	D4406	SHEET 5 OF 6
APPROVED	<i>MP</i>	TITLE	SCALE
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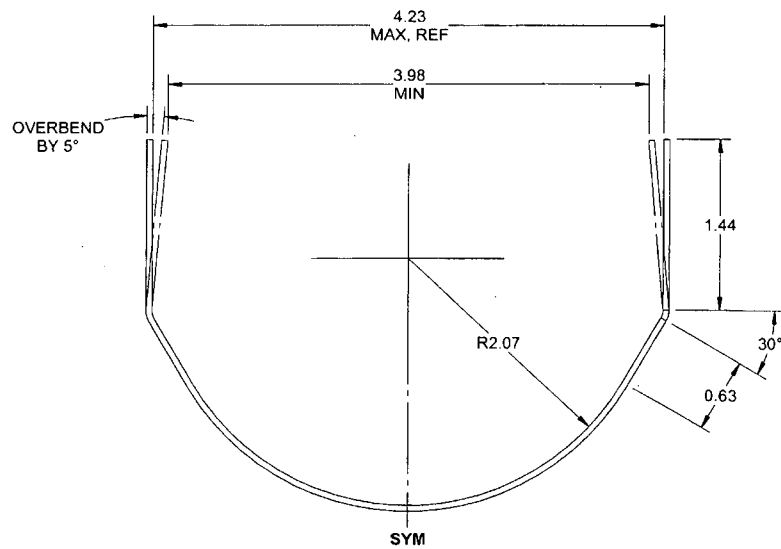
DETAIL D
SLOT DETAIL TYP
SCALE 6X

C3-4
C4-5



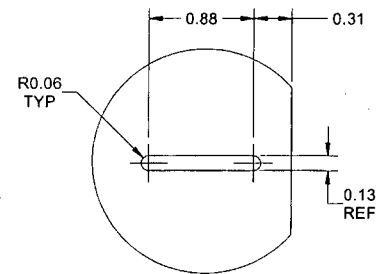
DETAIL E
SLOT DETAIL TYP
SCALE 6X

C2-4
C4-5



DETAIL C
DETAIL TYP
SCALE 6X

D2-4
D8-5



DETAIL F
SLOT DETAIL TYP
SCALE 6X

C1-4
B1-5

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2011-08-29
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MFG. APPR.	<i>[Signature]</i>	SHEET 6 OF 6	
APPROVED	<i>[Signature]</i>	TITLE WEARPLATE ASSY	SCALE
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